

Work Order ID 80241

80241

Page 1

February-15-12 1:39:30 PM

Item ID: D4353-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bearpaw Insert

Start Date: 2/15/12 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/02/12 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4353

B

120

0.00

120

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D4355-3 File
Blank: 5.125" x 4.375" x 1.00"

W 12.02.16 (6)

130

0.00

130

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per FolioFB051 and Dwg
FOLIO REV: AA
DWG REV: B

3-Deburr

12/10/10

(6)

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Page 2

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Set Up/
Run Hours

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Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC2- Inspect parts off machine FAI/FAIB

0.00

140

QC

Memo

0.00

Quality Control

150

QC8- Inspect parts - second check

0.00

150

QC

Memo

0.00

Quality Control

151

Identify as per dwg & Stock Location: *SI 1397* 0.00

151

Packaging

Memo

0.00

Packaging

(Lex) Sp 12-04-05

Work Order ID 80241***80241***

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Accept

N900040100

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NS1

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 12/04/05

MLJ 12/04/05

Picklist Print

February-15-12 1:39:30 PM

Page 1

Work Order ID: 80241
Parent Item: D4353-3
Parent Item Name: Bearpaw Insert

Start Date: 2/15/12
Start Qty: 6.00

Required Date: 3/02/12
Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 11-04-13 JLM VERIFIED BY:DD

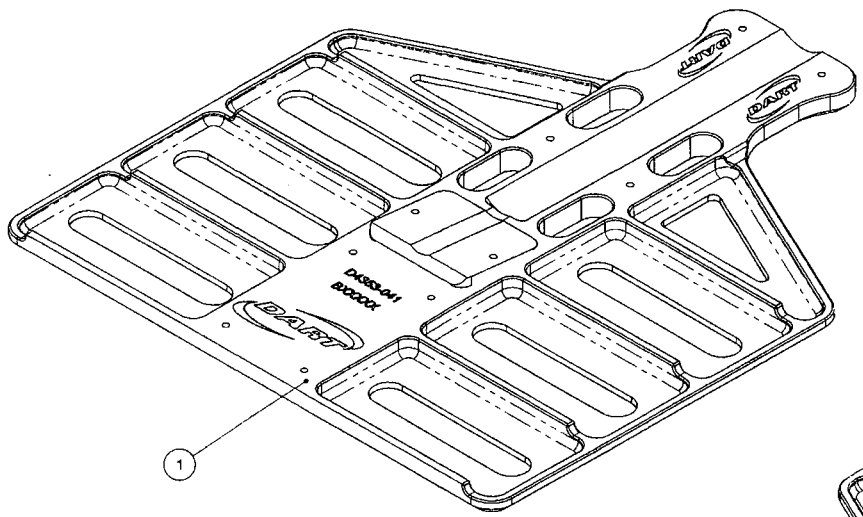
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No				sf	666.5243		1.2631579			
UHMW 1" Black													

Location	Loc Qty	Loc Code
MAT018	408.88	
120035	88.88	
120401	320	
MAT019	257.6443158	
117321	74.6	
117738	93.8	
117819	83.3	
118814	1.5	
119145	4.44431579	

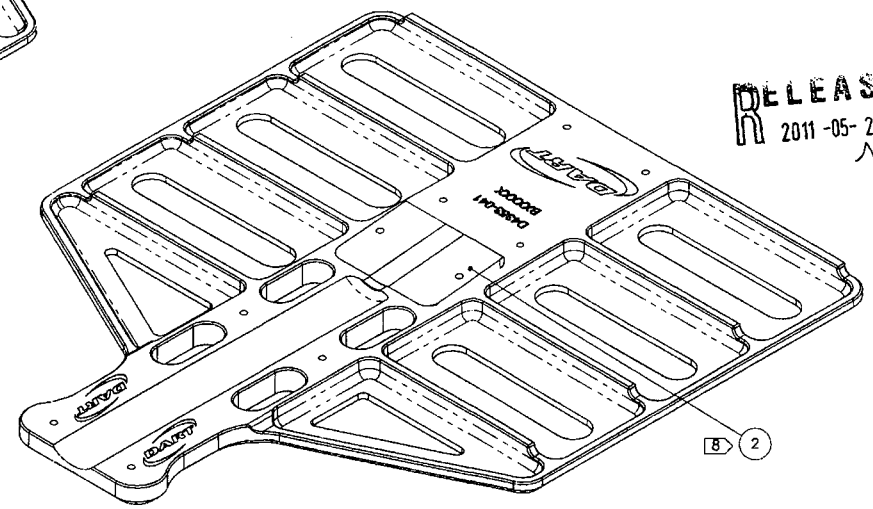
12-02-16

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	X	D4353-041	429 BEARPAW ASSEMBLY
1	1	D4353-1	429 BEARPAW
2	1	D4353-3	429 BEARPAW INSERT



D4353-041 429 BEARPAW ASSEMBLY



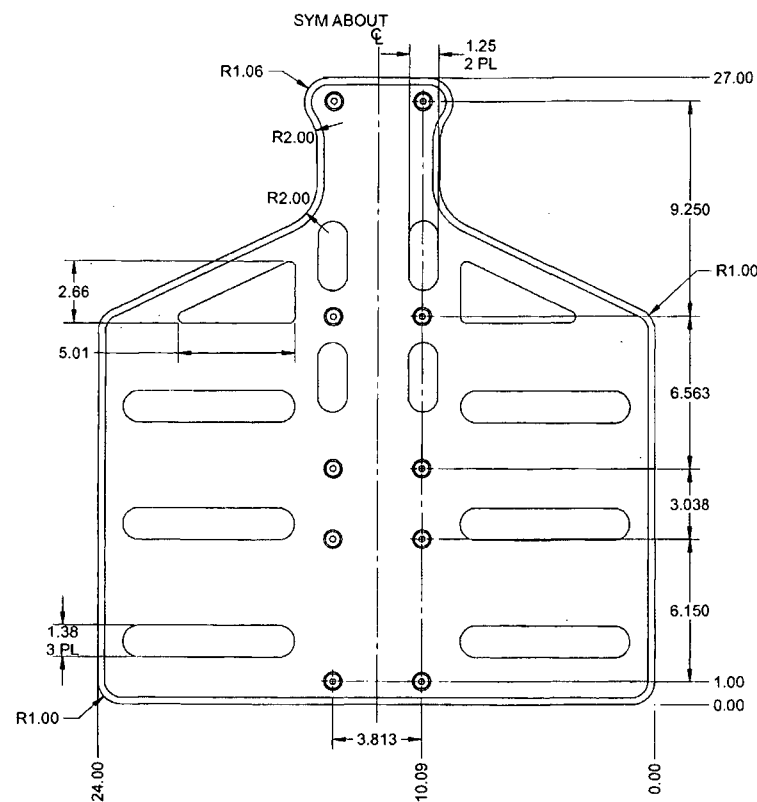
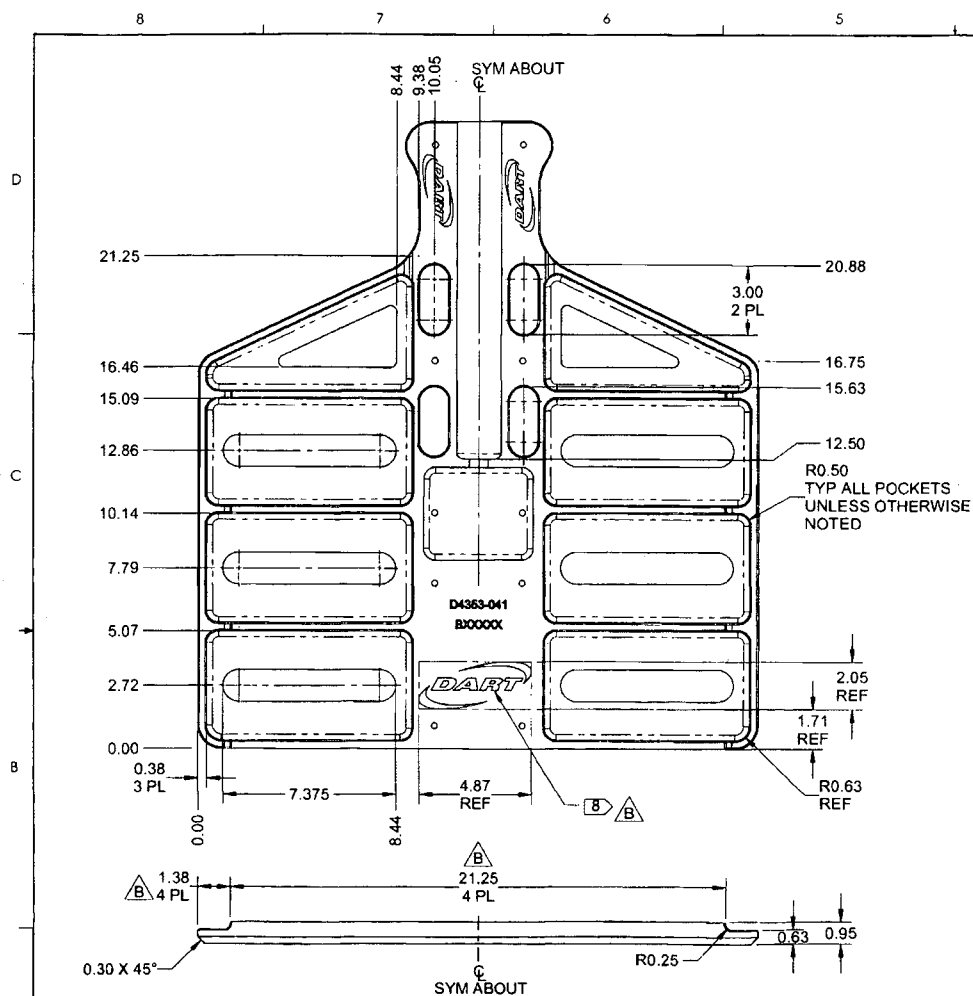
RELEASED
2011-05-25
AM

W/080241

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 7.45 lbs
 - 8) PRESS FIT

B	SHT 1 WEIGHT CORRECTED WAS 8.24 lbs. SHTS 1-3 DART LOGOS UPDATED. SHT 2, ZONE B8, AFT POCKET REDUCED. RIB INCREASED IN HEIGHT. SHT 3 SECTS. B,C & D, RIB INCREASED IN HEIGHT.	AJS	11.04.26
A	NEW ISSUE	AJS	11.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.04.26		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4353 TITLE 429 BEARPAW ASSEMBLY SCALE NTS REV. 8 SHEET 1 OF 4 <small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

8 7 6 5 4 3 2 1



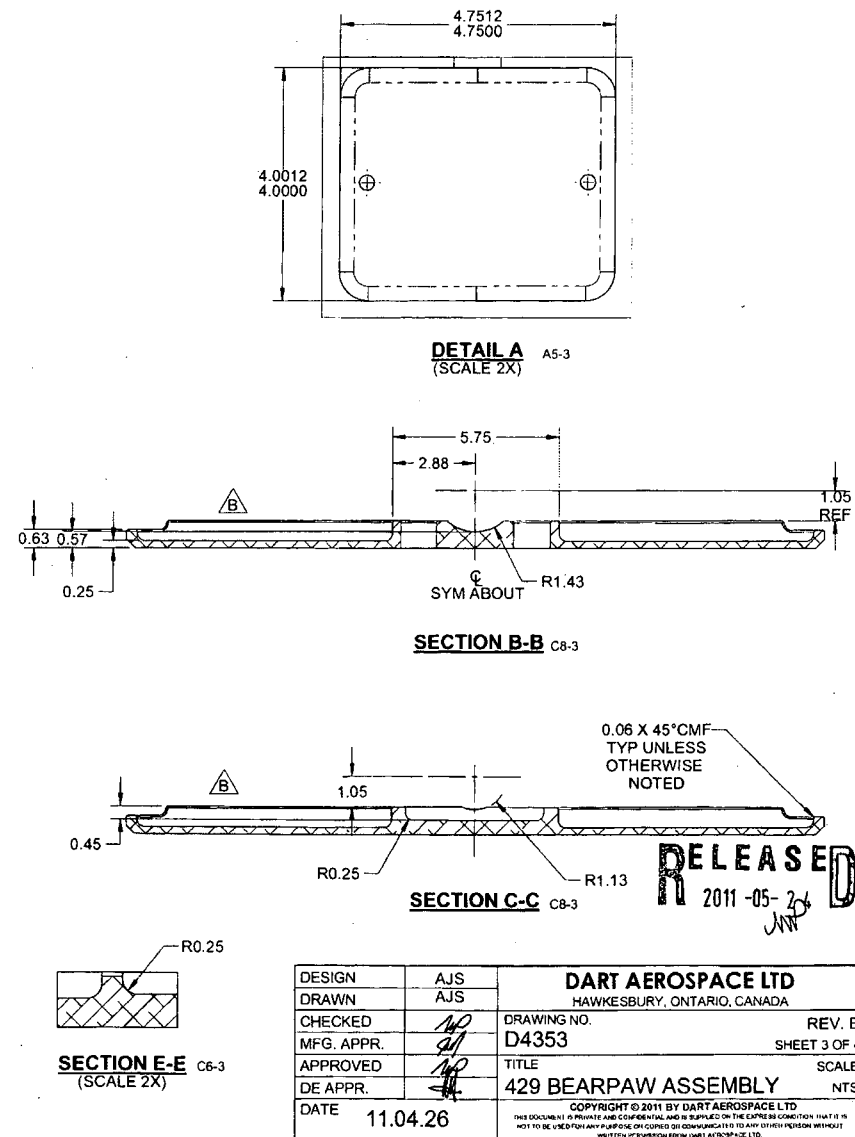
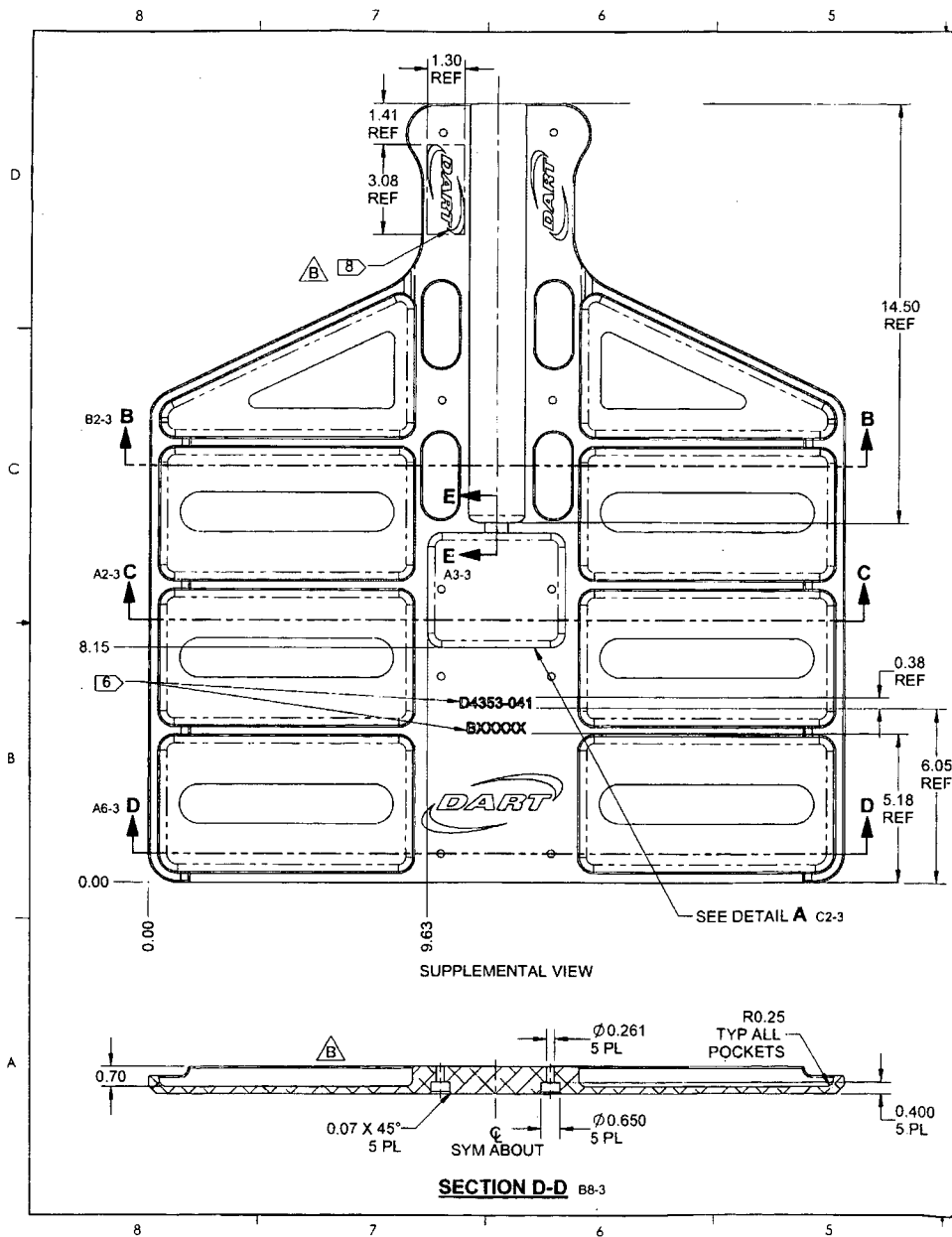
D4353-1 429 BEARPAW

RELEASED
2011-05-04
JN

NOTES:

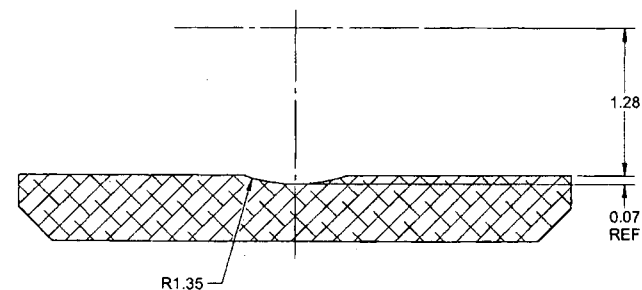
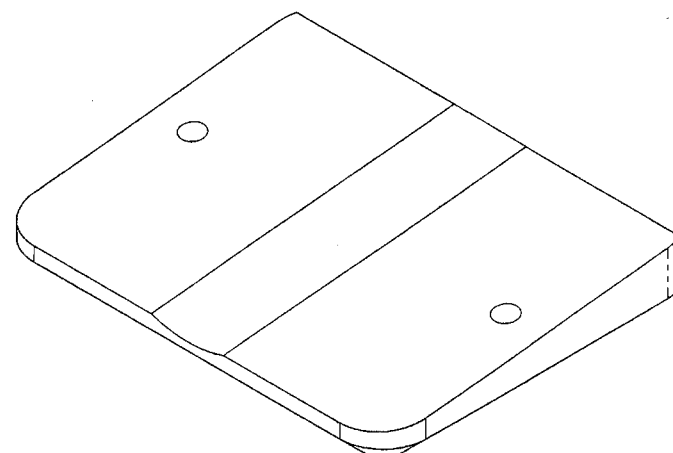
- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: ENGRAVE WITH DART ASSEMBLY P/N "D4353-041" AND B/N "BXXXXX" 0.005 - 0.010 DP AS SHOWN
- 7) WEIGHT: 7.07 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.003 - 0.005 DP.

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MFG. APPR.	<i>[Signature]</i>	TITLE 429 BEARPAW ASSEMBLY	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	SCALE	NTS
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DATE	11.04.26		



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MFG. APPR.	<i>[Signature]</i>	D4353	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	429 BEARPAW ASSEMBLY	NTS
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2011-05-26
JW



D4353-3 429 BEARPAW INSERT

RELEASED
2011-05-24

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1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1,000 THICK.
2) FINISH: NONE
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4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT: 0.38 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4353 TITLE 429 BEARPAW ASSEMBLY COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRINTED AND CANNOT BE REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN CONSENT OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR CONSTRUCTION TO ANY OTHER PROJECT WITHOUT THE WRITTEN CONSENT OF DART AEROSPACE LTD.	REV. E
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APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.04.26		

FIRST ARTICLE INSPECTION CHECKLIST